

Date: Wednesday, 3/26/2008 9:52:44 AM  
 User: Kim Johnston

## Process Sheet

|  |                                      |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : DOOR DOUBLER          |
| Job Number : 38163                             |                                      |
| Estimate Number : 12680                        |                                      |
| P.O. Number :                                  | Part Number : D3594041               |
| This Issue : 3/26/2008 S.O. No. :              | Drawing Number : D3594 REV A         |
| Prsht Rev. : NC                                | Project Number : N/A                 |
| First Issue : 1 / 1 Type : SMALL / MED FAB     | Drawing Revision : A                 |
| Previous Run : 33874                           | Material :                           |
| Written By :                                   | Due Date : 4/4/2008 Qty: 10 Um: Each |
| Checked & Approved By : <u>JD 08.3.27</u>      |                                      |
| Comment : Est Rev : A New Issue 07-01-22 EC    |                                      |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M6061T6S080 | 6061-T6 .080 Sheet |
|-----|-------------|--------------------|



1.6



Comment: Qty.: 0.0578 sf(s)/Unit Total : 0.5775 sf(s)

6061-T6 .080 Sheet

Batch: 104921

IR 8-3-08

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: AProg Rev: A

IR 8-3-08

(26)

2-Deburr if necessary

CB 08/04/02

(26)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



IR 8-3-08



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

CB 08/04/02 (26)

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

C'SINK AS [PER dwg d3594

CB 08/04/04 (26)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:52:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 38163

Part Number: D3594041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/04 (26)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SS

08-04-04

X26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/04/04 (28)

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Anchor nuts

Batch:

M105889

(19X)

\*

M107938

(7X)

EB08/05/06

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

Batch:

M1021

EB08/05/06

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D3594

EB08/05/06 (26)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/06 (26)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

st240

PC 8/7 (26)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 3/26/2008 9:52:44 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 38163

Part Number: D3594041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF*

08-05-07

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

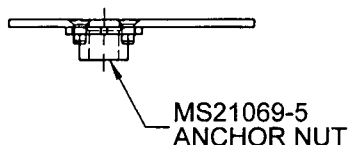
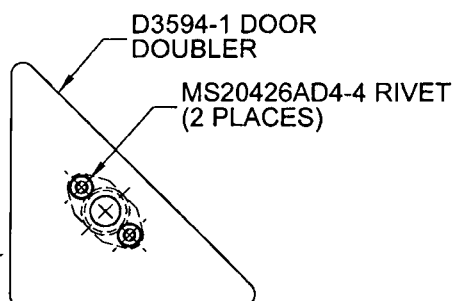
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

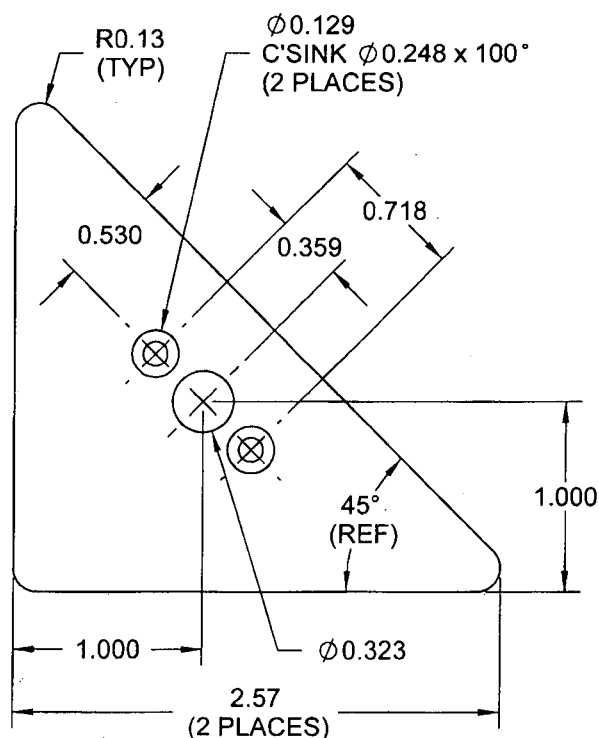


**DART****RELEASED**  
07.07.11  
Per [signature]

|                         |                         |  |                        |
|-------------------------|-------------------------|--|------------------------|
| DESIGN<br>13            | DRAWN BY<br>13          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[signature]  | APPROVED<br>[signature] | DRAWING NO.<br><b>D3594</b>                              | REV. A<br>SHEET 1 OF 3 |
| DATE<br><b>07.04.13</b> | TITLE<br><b>DOUBLER</b> |  | SCALE<br>1:1           |
| REV<br>A                | DATE<br>07.04.13        | DESCRIPTION<br>NEW ISSUE                                 |                        |

**D3594-041 DOOR DOUBLER ASSEMBLY**   
SCALE 1:2

| QTY<br>-041 | P/N          | DESCRIPTION           |
|-------------|--------------|-----------------------|
| X           | D3594-041    | DOOR DOUBLER ASSEMBLY |
| 1           | D3594-1      | DOOR DOUBLER          |
| 1           | MS21069-5    | ANCHOR NUT            |
| 2           | MS20426AD4-4 | RIVET                 |

**D3594-1 DOOR DOUBLER** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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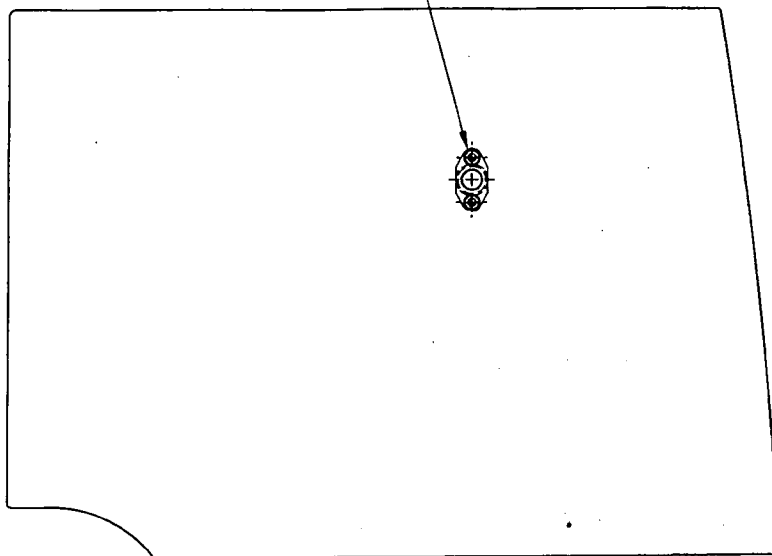


|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3594</b>                              | REV. A<br>SHEET 2 OF 3 |
| DATE<br><b>07.04.13</b>       |                                | TITLE<br><b>FLOOR DOUBLER ASSEMBLY</b><br>SCALE<br>1:3   |                        |

**RELEASED**  
07.07.11

Per 60 #1021

MS20426AD4-4 RIVET  
(2 PLACES)



MS21069-5  
ANCHOR NUT



D3594-3 FLOOR DOUBLER (D3594-043)  
D3594-4 FLOOR DOUBLER (D3594-044)

**D3594-043 FLOOR DOUBLER ASSEMBLY**  
**(D3594-044 OPPOSITE)**

| QTY<br>-043 | QTY<br>-044 | P/N          | DESCRIPTION             |
|-------------|-------------|--------------|-------------------------|
| X           |             | D3594-043    | FLOOR DOUBLER ASS'Y, LH |
|             | X           | D3594-044    | FLOOR DOUBLER ASS'Y, RH |
| 1           |             | D3594-3      | FLOOR DOUBLER, LH       |
|             | 1           | D3594-4      | FLOOR DOUBLER, RH       |
| 1           | 1           | MS21069-5    | ANCHOR NUT              |
| 2           | 2           | MS20426AD4-4 | RIVET                   |

**NOTES:**

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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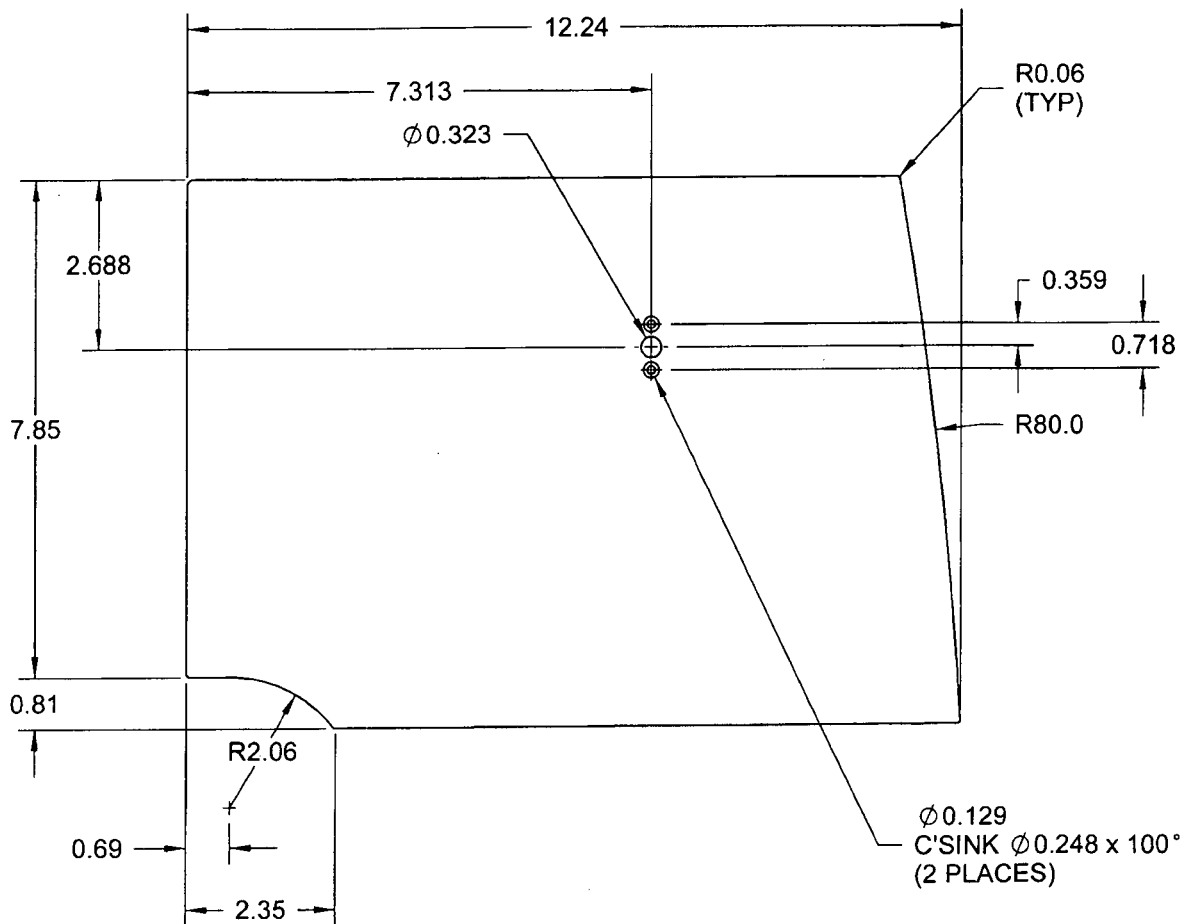


|                  |                  |   |                        |
|------------------|------------------|---|------------------------|
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| CHECKED<br>H     | APPROVED<br>H    | DRAWING NO.<br>D3594                              | REV. A<br>SHEET 3 OF 3 |
| DATE<br>07.04.13 | TITLE<br>DOUBLER |   | SCALE<br>1:3           |

RELEASED

07.07.11 13

PER 60041001



**D3594-3 FLOOR DOUBLER**  
**(D3594-4 OPPOSITE)**

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